

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022137**Date Inspected:** 25-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly:

This QA Inspector observed the following work in progress:

OBG Seg 13AE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3007C-101 [Floor Beam (FB) 3120A to RA stiffener (RS) 3070 on Bottom Panel (BP), complete joint penetration (CJP) weld, at panel point (PP) 120]. The welder is identified as 050242 and was observed welding in 3G position. ZPMC Quality Control (QC) was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-T-2232-ESAB.

The SMAW process on weld joint no: Seg3007AD-118 (FB3122A to I-rib stiffener, CJP weld at PP119-1500).

The welder is identified as 037743 and was observed welding in 4G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

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Repair welding of weld joint no: Seg3007R-003 [Deck Panel (DP) diaphragm splice joint (for DP3074 and DP3075), CJP weld, at PP117.5]. The welder is identified as 200113 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20472 Rev-0.

The FCAW process on weld joint no: Seg3007R-200 [FB3101A to Side Panel (SP) 3058A, fillet weld at PP117.5]. The welder is identified as 200113 and was observed welding in 3F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: B-T-2132-ESAB.

ABF personnel performing Magnetic Particle Testing (MT) on weld joint no: Seg3007X-509 (Edge Beam EB3010 to Floor Beam, at PP119-1500) after repair excavation.

OBG Seg 13AW:

ZPMC personnel performing fit-up of RS3476 stiffeners with BP SA3168A and FB3202A at PP120. ZPMC QC was identified as Liu Hua Jie.

The SMAW process on weld joint no: Seg3013AD-035 (Floor Beam to Side Panel, CJP weld at PP120). The welder is identified as 069683 and was observed welding in 4G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
